

Date: Tuesday, 17/02/2009 10:18:25 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PACKER
Job Number : 45813	
Estimate Number : 10225	
P.O. Number :	Part Number : D2150
This Issue : 17/02/2009 S.O. No. :	Drawing Number : D2150 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 43595	Material :
Written By :	Due Date : 05/03/2009 Qty: 30 Um: Each
Checked & Approved By : <u>JUL 09-02-17</u>	
Comment : Est C 00.11.27 Re-format (mpp 2101) EC	
Est Rev:D 06-08-23 Now on Waterjet JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.0263 sf(s)/Unit Total : 0.7875 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch: 106272

IB 9-2-27

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2150

Dwg Rev: A

Prog Rev: A

IB 9-2-27

(40)

2-Deburr if necessary

IB

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 9-2-27

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 09/03/03 counter X40

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

m-h

09/08/02

(40X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 17/02/2009 10:18:26 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PACKER

Job Number: 45813

Part Number: D2150

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MP/Fd

09/03/03

(140)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

10:10

OVEN TEMPERATURE:

320°

FINISH TIME:

10:40

Fd 09/03/04

(40)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-03-04

(40)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 17

SS 09/03/05 (40)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/05 (40)

Job Completion



U 09.03.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: W5813	
Description: Packer		Part Number: D2150	
Inspection Dwg: D2150 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.740	+/-0.010	.741	X			
2.050	+/-0.010	2.055	X			
0.231	+/-0.010	.232	X			
1.217	+/-0.010	1.214	X			
1.559	+/-0.010	1.562	X			
2.300	+/-0.010	2.303	X			
1.560	+/-0.010	1.562	X			
0.250	+/-0.010	.254	X			
1.328	+/-0.010	1.330	X			
0.342	+/-0.010	.343	X			
Ø0.098	+0.005/-0.000	.102	X			
Ø0.171	+0.005/-0.000	.172	X			
0.040	+/-0.010	.041	X			

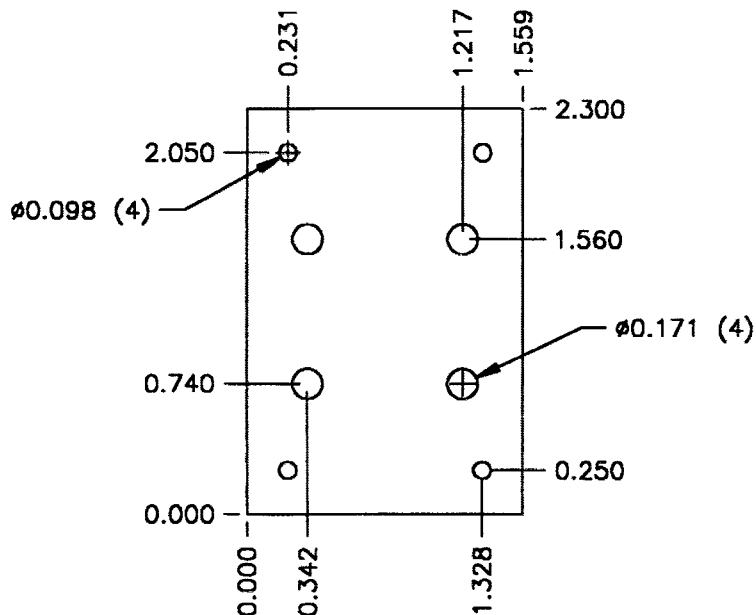
Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-2-07	Date: 07/03/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.28	New Issue	KJ/JLM	[Signature]



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	K HAND	DRAWING NO.	REV. A
CHECKED	APPROVED	D2150	SHEET 1 OF 1
DATE	TITLE	PACKER	SCALE
95:05:01			1:1

RELEASED
96/06/13 BWS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. WS813

MATERIAL: 2024-T3, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS